



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-023
Job Sheet 194169



Part No: D350-636-023

Job Qty: 1 pcs

Part Name: AS350/355 - Skidtubes - Standard w/ Heavy-Duty Wearplates - LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/26/19

Job Tracking No:

Due Date: 4/30/19

Created By: Shannon Hadley

Type: Stock

Description:

Note: D4168-051 REV.C, IIN-D350-636 REV.K IPP REV.A 18.11.29 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Skidtubes - 1	1 pcs	4/30/19		0.00	5.25	Skidtubes - 1 - B4B			BE
							Skidtubes - 2 - B4B			
							Skidtubes - 3 - B4B			
							Skidtubes - 4 - B4B			
							Skidtubes - 5 - B4B			
							Skidtubes - 6 - B4B			
							Skidtubes - 7 - B4B			
120	QC 10	1 pcs	4/30/19		0.00	0.00	QC 10 - 10		DAS 24 9-89	MAY 03 2019
							QC 10 - 18			
							QC 10 - 24			
							QC 10 - 43			
							QC 10 - 50			
							QC 10 - 58			
							QC 10 - 9			
130	QC 5	1 pcs	4/30/19		0.00	0.00	QC 5 - 10		DAS 68 9-89	MAY 03 2019
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			

140 Handfinish - 1-1 Chemical-B4B	1	4/30/19	0.00 0.99	Handfinish - 1 - 1 - B4B
				Handfinish - 1 - 2 - B4B
				Handfinish - 1 - 3 - B4B
				Handfinish - 1 - 4 - B4B
				Handfinish - 1 - 5 - B4B
				Handfinish - 1 - 6 - B4B
				Handfinish - 1 - 7 - B4B
				Handfinish - 1 - 8 - B4B
				Handfinish - 1 - 9 - B4B
				Handfinish - 1 - 10 - B4B
				Handfinish - 1 - 11 - B4B
				Handfinish - 1 - 12 - B4B
				Handfinish - 1 - 13 - B4B
				Handfinish - 1 - 14 - B4B
				Handfinish - 1 - 15 - B4B
				Handfinish - 1 - 16 - B4B
				Handfinish - 1 - 17 - B4B
				Handfinish - 1 - 18 - B4B
				Handfinish - 1 - 19 - B4B
				Handfinish - 1 - 20 - B4B
				Handfinish - 1 - 21 - B4B
				Handfinish - 1 - 22 - B4B
150 QC 7	1	4/30/19	0.00 0.00	QC 7 - 10
				QC 7 - 13
				QC 7 - 14
				QC 7 - 15
				QC 7 - 17
				QC 7 - 18
				QC 7 - 19
				QC 7 - 2
				QC 7 - 28
				QC 7 - 3
				QC 7 - 30
				QC 7 - 34
				QC 7 - 36
				QC 7 - 37
				QC 7 - 41
				QC 7 - 47
				QC 7 - 48
				QC 7 - 51
				QC 7 - 58
				QC 7 - 59
				QC 7 - 60
				QC 7 - 9
				QC 7 - 68
				QC 7 - 50
				QC 7 - 67
				QC 7 - 40

MS

D.R. 19/05/06

[illegible]

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275 DC - 1 - B4B	1	4/30/19	0.00 0.00	DC - 1 - B4B	21	JUL 1 1 2019
				Packaging 3 - 36 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 26 - B4B		
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				Packaging 3 - 14 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 8 - B4B	75	JUL 1 1 2019
				Packaging 3 - 7 - B4B	9-89	
				Packaging 3 - 6 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 2 - B4B		
270 Packaging 3-1 - Stock - B4B	1	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B		
				QC 4 - 68	75	JUL 1 1 2019
				QC 4 - 46	9-89	
				QC 4 - 9		
				QC 4 - 69		
				QC 4 - 58		
260 QC 4	1	4/30/19	0.00 0.00	QC 4 - 28		
				Packaging 1 - 36 - B4B		
				Packaging 1 - 35 - B4B		
				Packaging 1 - 34 - B4B		
				Packaging 1 - 33 - B4B		
				Packaging 1 - 32 - B4B		
				Packaging 1 - 31 - B4B		
				Packaging 1 - 30 - B4B		
				Packaging 1 - 29 - B4B		
				Packaging 1 - 28 - B4B		
				Packaging 1 - 27 - B4B		
				Packaging 1 - 26 - B4B		
				Packaging 1 - 25 - B4B		
280 QC 21 - FG	1	4/30/19	0.00 0.00	QC 21 - FG - 70	21	JUL 1 1 2019
				QC 21 - FG - 21	9-89	
				DC - 2 - B4B	12	
				QC 21 - FG - 53	5-89	

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
Descriptions: D4168-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill
then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER
POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168
sheet 4 (D4168-5 details). Drill using drill jig DT8150 & DT8863A for first side only DT8863B for second side 4- Locate
DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section DE-DE. Open to 0.500" using hole saw.
VERIFY AND RECORD FWD BEND ANGLE. 5- Drill tow ring hole using DT9616 detail "DA" 6- Drill most FWD wearplate
hole using DT9678 locating off of 66.54" hole. 7- Open up holes of Detail DA to 0.297" (total of 2 holes per side) and .201"
(total of 1 hole per side using DT9616) 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from
bending as per QSI 004 A/R Aluminum Rod batch: 10- Grind welds flush as per Dwg D4168 and QSI 004. Fill grooves in bend left from
120 - (QC10- Inspect visual per QSI004- ground welds)
130 - (QC5- Inspect part completeness to step on W/O)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (QC7-Inspect Chemical Conversion Coat)
160 - 1-Open up holes using hole saw of Detail DB and ground handling section EN-EN to 0.625" (total of 8 holes per
side) as per Dwg D4168. Open wearplate holes to size as per dwg (4 holes per side), section EP-EP 4-Chamber holes of
Detail DB, ground handling section AL-AL per dwg D4168 (welding instructions on sheet 8) 5-Deburr and blow out all
chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI
015, let cure for 12hrs. A/R Sikaflex-291 batch: 0174342 exp. date: 08/04/19 8- Weld spacers D2743 as per dwg D4168 and D4170-1 & QSI004 (welding instructions on
sheet) A/R Aluminum Rod batch: 039011 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling
holes section (total of 4 places per side) as per dwg D4168, section EN-EN 12-C'bore section CG-CG. ADJUST
TOOLING AS REQUIRED. VERR BY: 13- Deburr holes, ensure tube is free of all scratches before
sending to paint. *****
170 - QC10- Inspect visual per QSI004- ground welds)
180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do
not acid etch.
200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349
BATCH: 5179532 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5184740
210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
230 - (Assemble as per dwg) 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting
D3488-3, wearshoes and ground handling hardware as per dwg D4168 SIKAFLEX 241 BATCH: 5174342 EXP
DATE: 04-12-19 5-Coat all exposed fasteners with "LPS Procyon" batch: M133690
240 - (QC5- Inspect part completeness to step on W/O)
250 - (Pick Kit) If making a D350-636-215 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A
260 - (QC4- 100% Inspect kits for completeness)*****ensure anti-seize is on AN8C21A bolts*****
270 - (Identify as per dwg & Stock Location:) Identify and pack for shipping as per PPPD350-636-023 Location
:FG071
275 - record fwd angle: 89.9
280 - (QC21- Final Inspection - Work Order Release)
Photocopy blue file and type labels per PPP D350-636-023 CHG 001

Part / Item	Component Name	Quantity	Operation
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	110-Skidtubes - 1
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B
ALSA-1032-225	Rivnut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B
D3488-3	Washer	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D3631-1	Bushing	7 pcs (7 ea)	230-Handfinish - 4-1-Assembly-B4B
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D4170-1	Bushing	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B
D4171-1	Bushing	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
MS21043-3	Nut	5 Ea (5 ea)	230-Handfinish - 4-1-Assembly-B4B
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1149C00332R	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1149C00363R	Washer	9 Ea (9 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1149C00332R	Washer	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1515H3L	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B

Job BOM

010162

Container

5166439

5160391

5126881

5156581

5163517

5186091-1

FM13707-1-2

5174235

5176392

5167090

X 5188184

5179042

5181110

5157749

X 5191500

5137508

5186390

50917569

5181777

5167203-1

5158079

5135100

5076017-2

5083559

5162189

5160967

5159549

5167203

5166718

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-LH	1	6	0
160-Skidtubes - 2 - B4B	D2744	1	16	0
	D2739	1	8	0
	D2743	8	135	0
230-Handfinish - 4-1-Assembly-B4B	ALSA-1032-225	4	1,681	0
	AN3C34A	1	12	0
	AN3C36A	4	351	0
	AN6C44A	4	317	0
	AN8C35A	4	132	0
	D2745	1	62	0
	D3488-3	8	168	0
	D3631-1	1	3	0
	D3873-1	8	197	0
	D4154-041	7	76	0
	D4170-1	1	5	0
	D4171-1	4	38	0
	MS21043-3	1	8	0
	MS21043-6	5	1,018	0
	MS21083C8	4	154	0
	MS21083C8	1	210	0
	NAS1149C00332R	4	5,640	0
	NAS1149C00363R	9	437	0
	NAS1149C00832R	1	340	0
	NAS1515H3L	4	358	0
250-Packaging 1-1 - Pick Kit - B4B	AN3C37A	1	52	0
	AN8C21A	2	85	0
	D2741	1	63	0
	MS21083C8	2	210	0
	NAS1149D0863J	2	465	0

Part Specifications	
Specifications could not be found.	

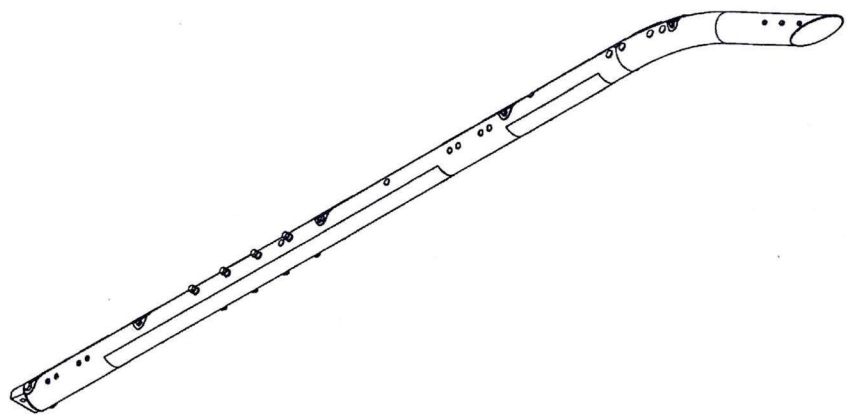
RELEASED
2018 OCT 19

APPROVED

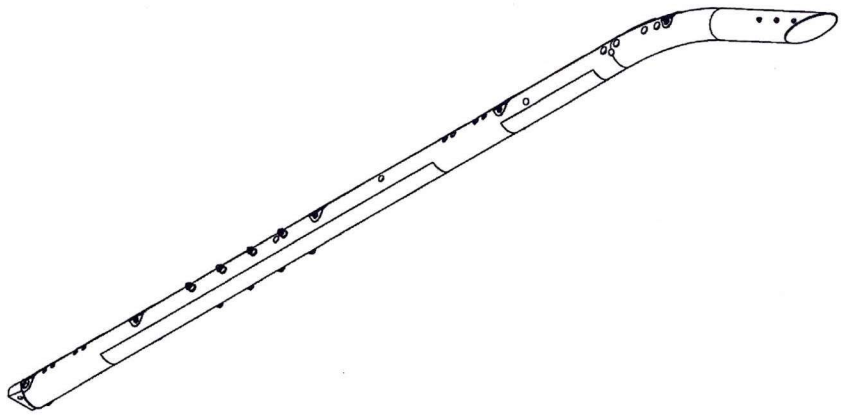
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CHECKED	MM
MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS
DATE	18.03.01

DART AEROSPACE USA, INC.	DART AEROSPACE USA, INC.
EUGENE, OR	EUGENE, OR
DRAWING NO.	D4168
REV. C	SHEET 2 OF 16
SCALE	NTS
350 SKIDTUBE ASSEMBLY	

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D4168-041 350 SKIDTUBE ASSEMBLY, LH



D4168-042 350 SKIDTUBE ASSEMBLY, RH

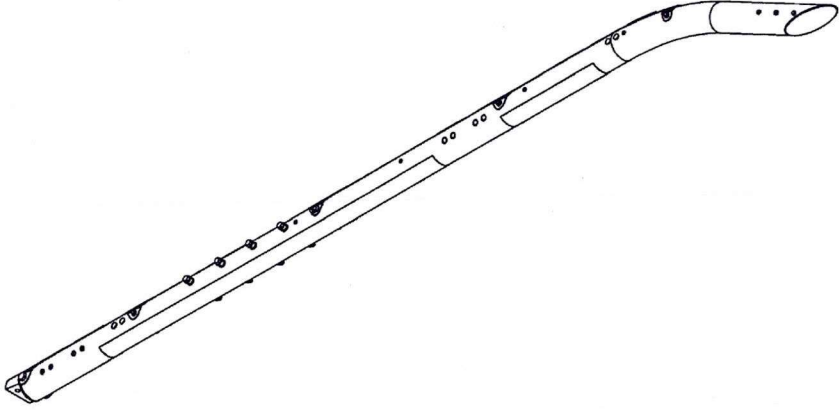
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2018 OCT 19

APPROVED

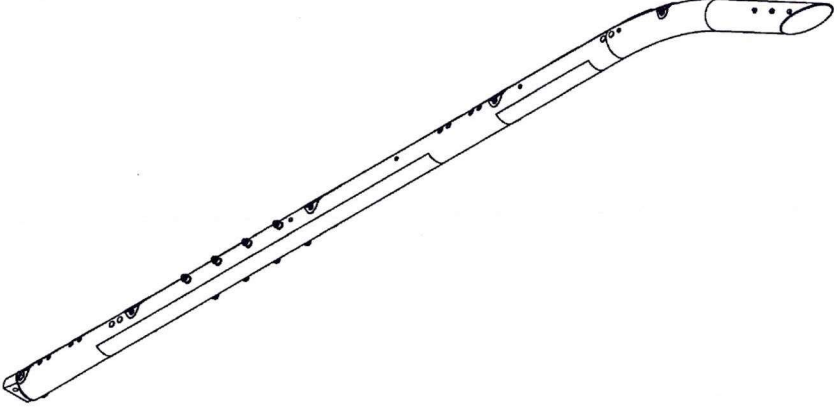
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CHECKED	MW
MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS
DATE	18.03.01

DART AEROSPACE USA, INC. EUGENE, OR	
DRAWING NO.	D4168
REV. C	SHEET 3 OF 16
SCALE	NTS
350 SKIDTUBE ASSEMBLY	
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D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH



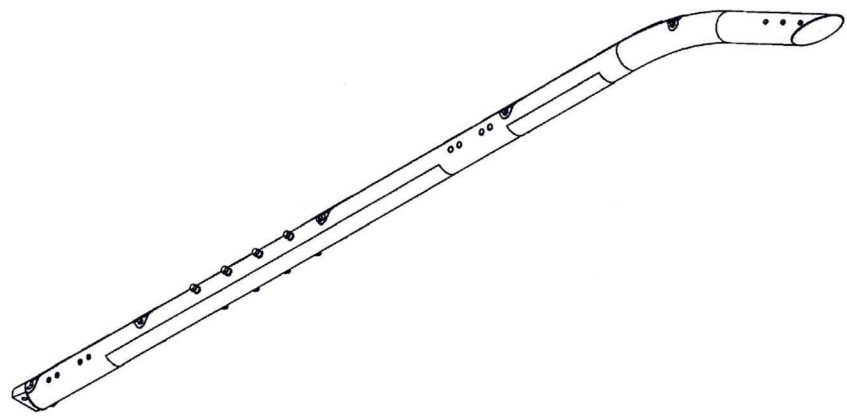
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2019 OCT 19

APPROVED

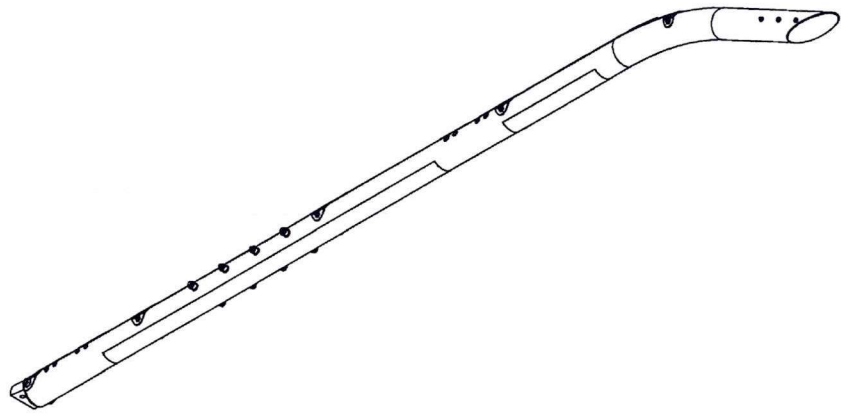
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MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS
DATE	18.03.01

DART AEROSPACE USA, INC.	
EUGENE, OR	
REV. C	
DRAWING NO.	D4168
TITLE	350 SKIDTUBE ASSEMBLY
SCALE	NTS
SHEET 4 OF 16	
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D4168-051 350 SKIDTUBE ASSEMBLY, LH



D4168-052 350 SKIDTUBE ASSEMBLY, RH



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DATE 18.03.01

DESIGN SC D4168-1H SKIDTUBE ASSEMBLY

DRAWN ZF

CHECKED MM

MFG. APPR. DD

APPROVED NO

DE APPR. DS

SCALE NTS

SHEET 5 OF 16

REV. C

DART AEROSPACE USA, INC.

EUGENE, OR

APPROVED

DATE 18.03.01

DESIGN SC

DRAWN ZF

CHECKED MM

MFG. APPR. DD

APPROVED NO

DE APPR. DS

SCALE NTS

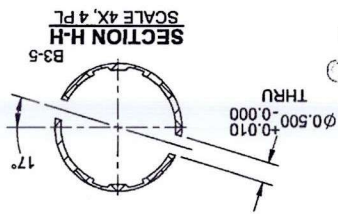
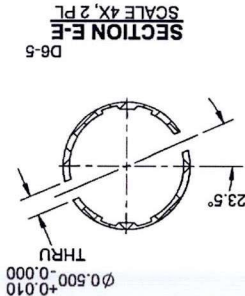
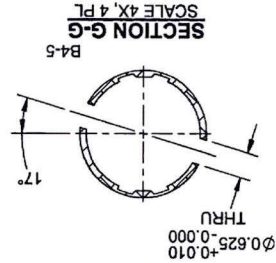
SHEET 5 OF 16

REV. C

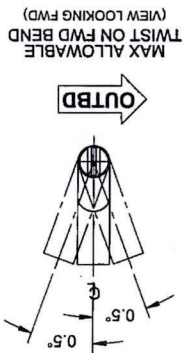
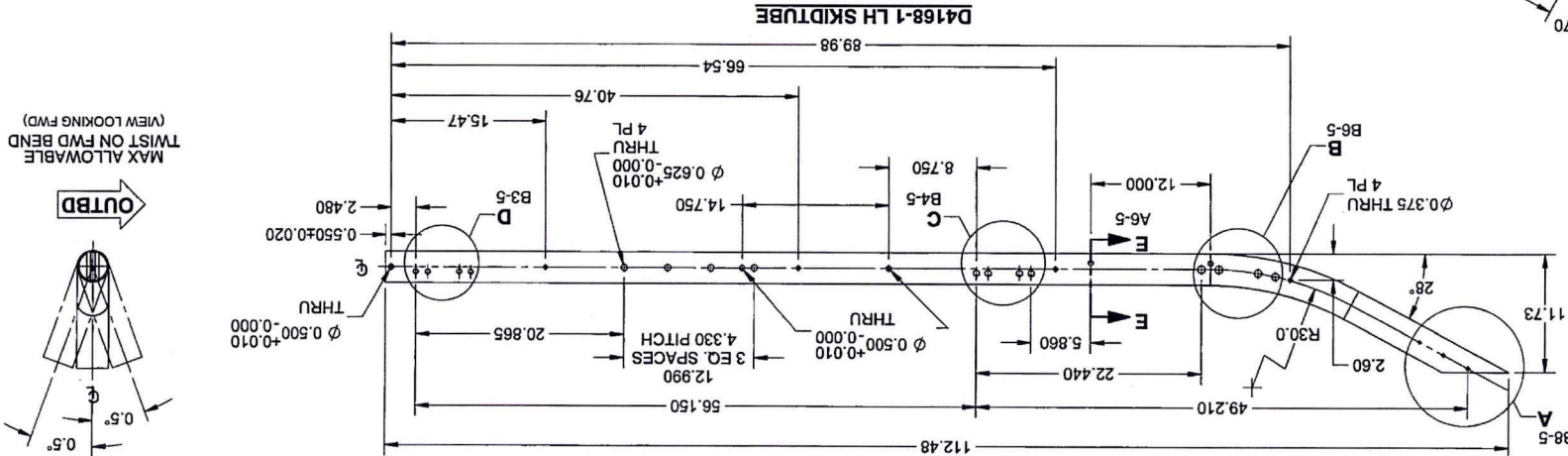
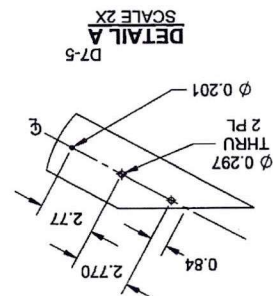
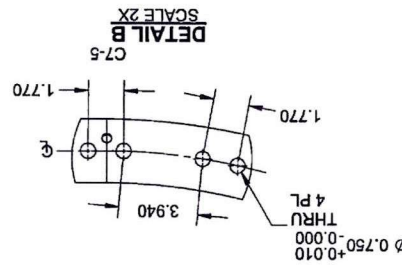
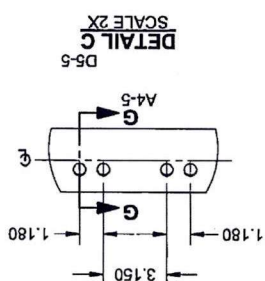
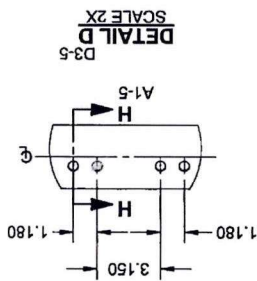
DART AEROSPACE USA, INC.

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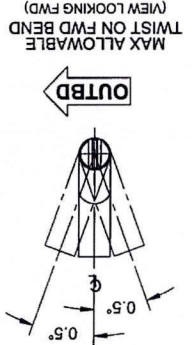
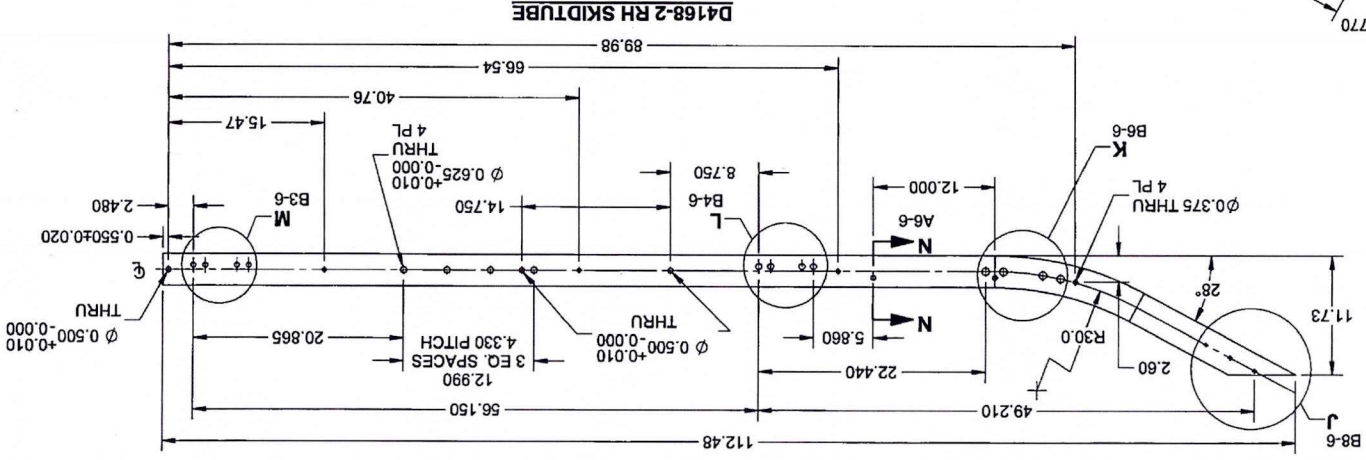
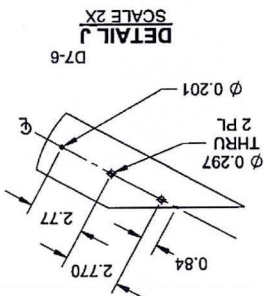
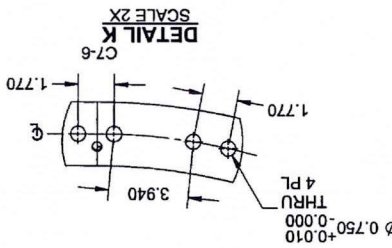
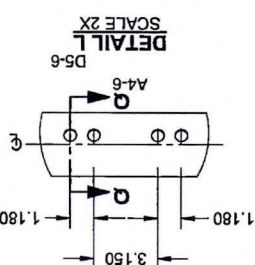
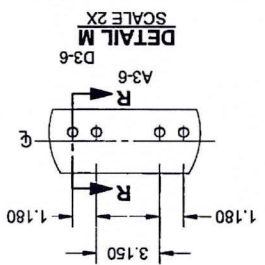
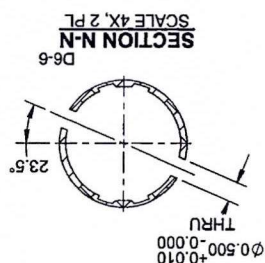
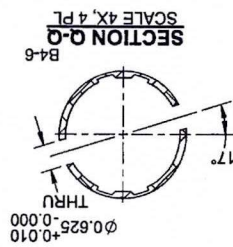
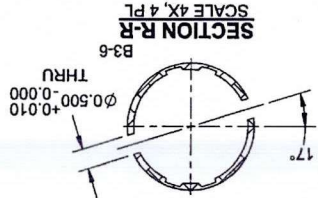
REPLACED
2013 OCT 19



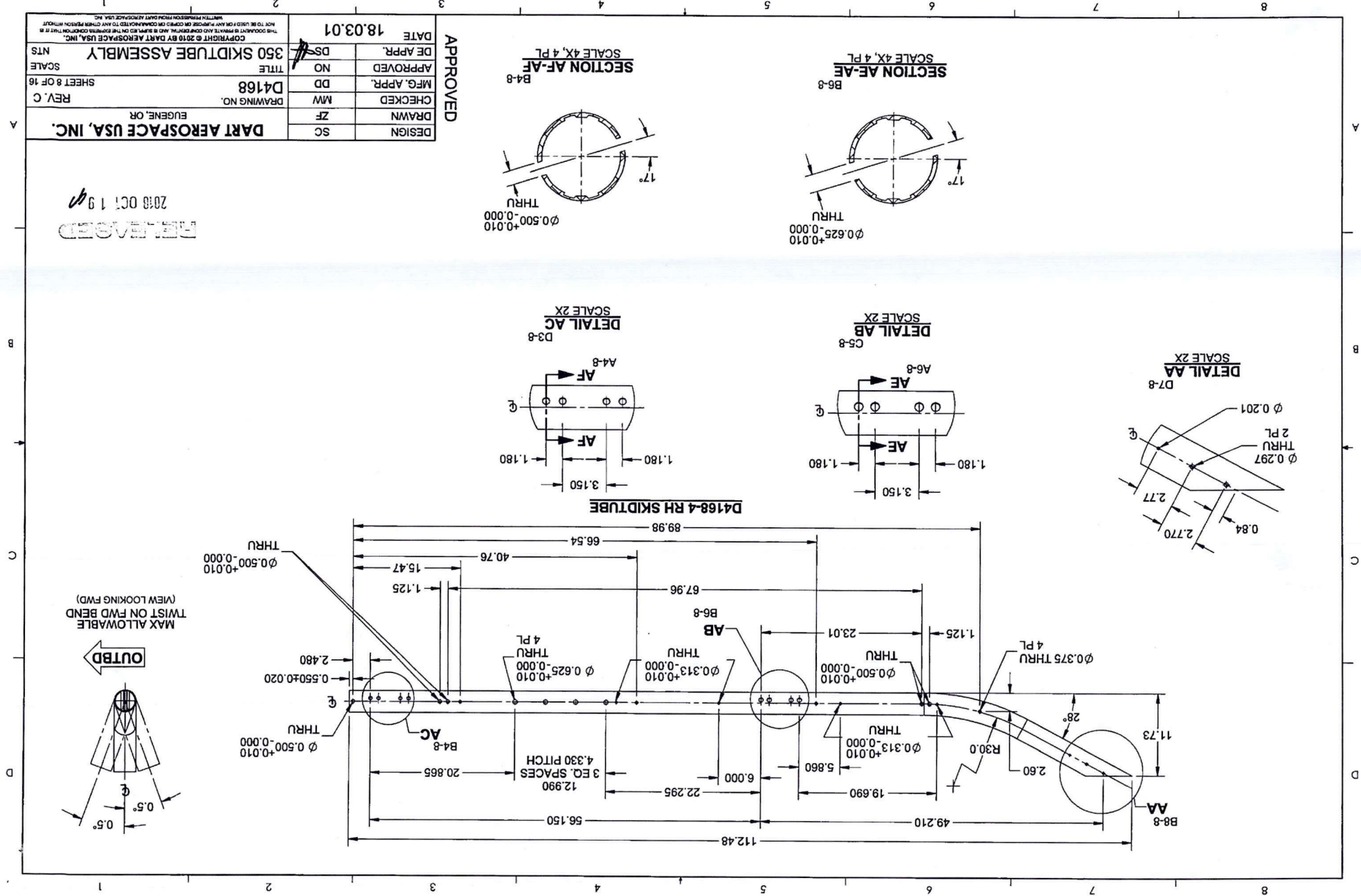
DART AEROSPACE USA, INC.	
REV. C	SHEET 6 OF 16
DRAWING NO.	D4168
CHECKED	MMW
DESIGN	SC
DATE	18.03.01
DE APPR.	DS
APPROVED	NO
MFG. APPR.	DD
TITLE	350 SKIDTUBE ASSEMBLY
SCALE	NTS
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CHECKED	MMW
MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS

APPROVED



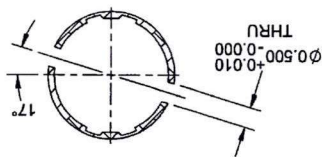
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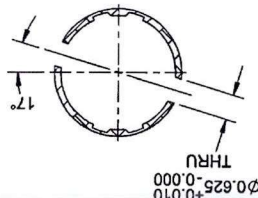
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DE APPR.	DS	APPROVED	NO	MFG. APPR.	DD	TITLE								

APPROVED

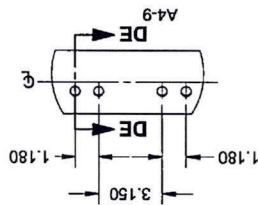
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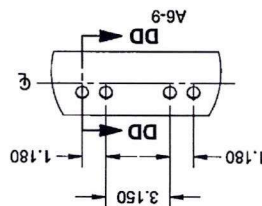
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SCALE 4X, 4 PL



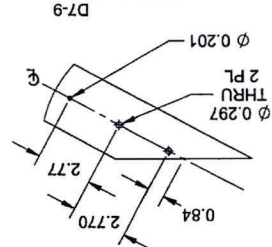
DETAIL DC
SCALE 2X



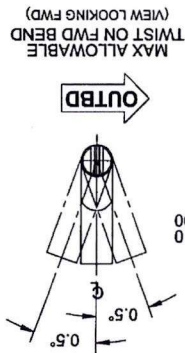
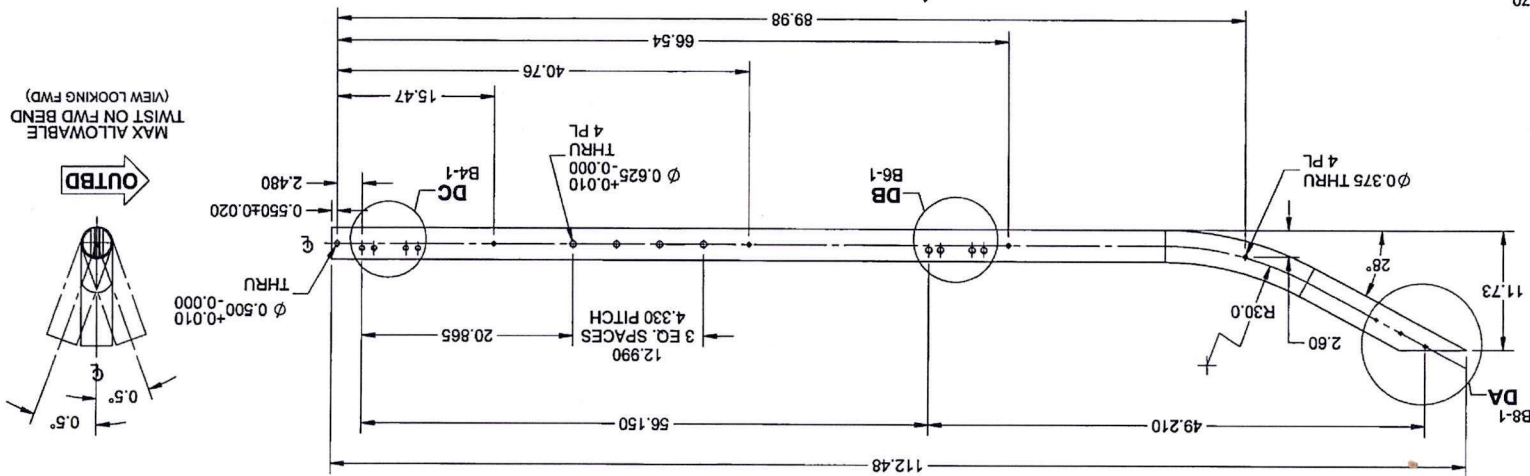
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SCALE 2X



DETAIL DA
SCALE 2X



D4168-5 LH SKIDTUBE



2019 OCT 19
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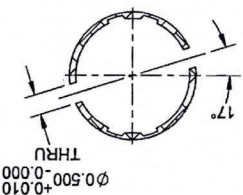
APPROVED

DESIGN	SC
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MFG. APPR.	DD
APPROVED	NO
DE APPR.	D9

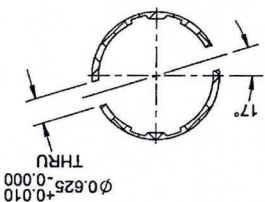
DATE 18.03.01

REV. C	SHEET 10 OF 18	SCALE	NTS
DART AEROSPACE USA, INC.	D4168	TITLE	350 SKIDTUBE ASSEMBLY
EUGENE, OR	DRAWING NO.		

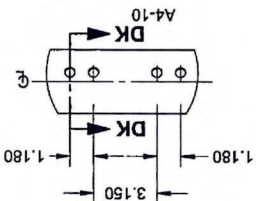
SECTION DK-DK
SCALE 4X, 4 PL



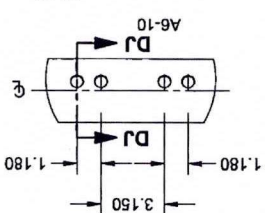
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SCALE 4X, 4 PL



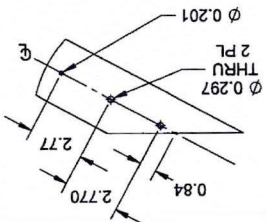
DETAIL DH
SCALE 2X



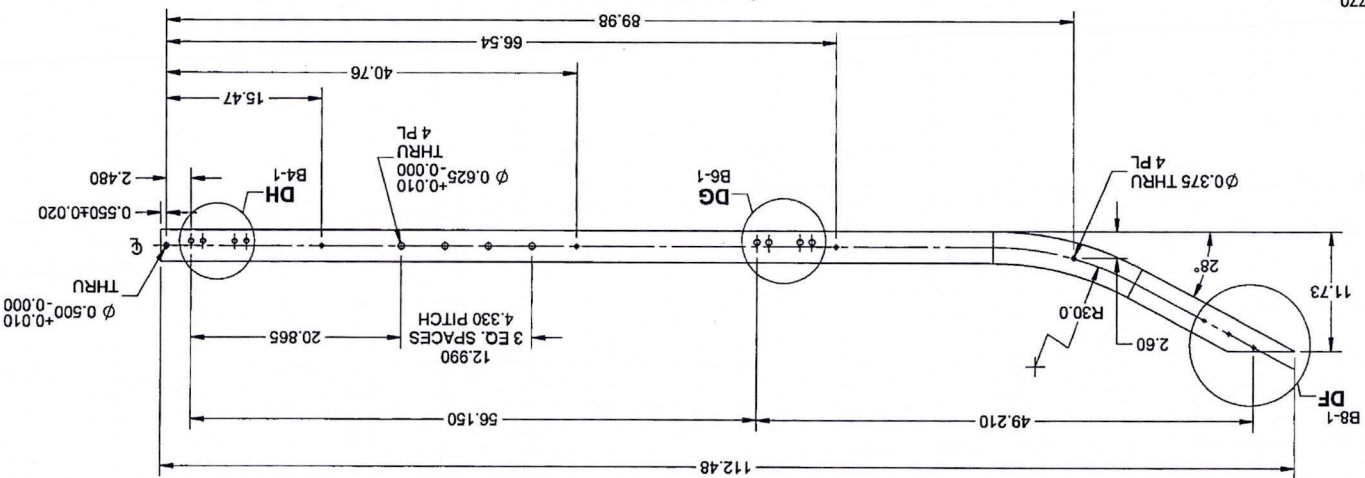
DETAIL DG
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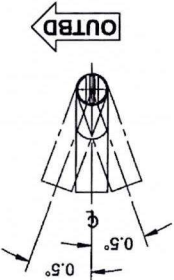
DETAIL DF
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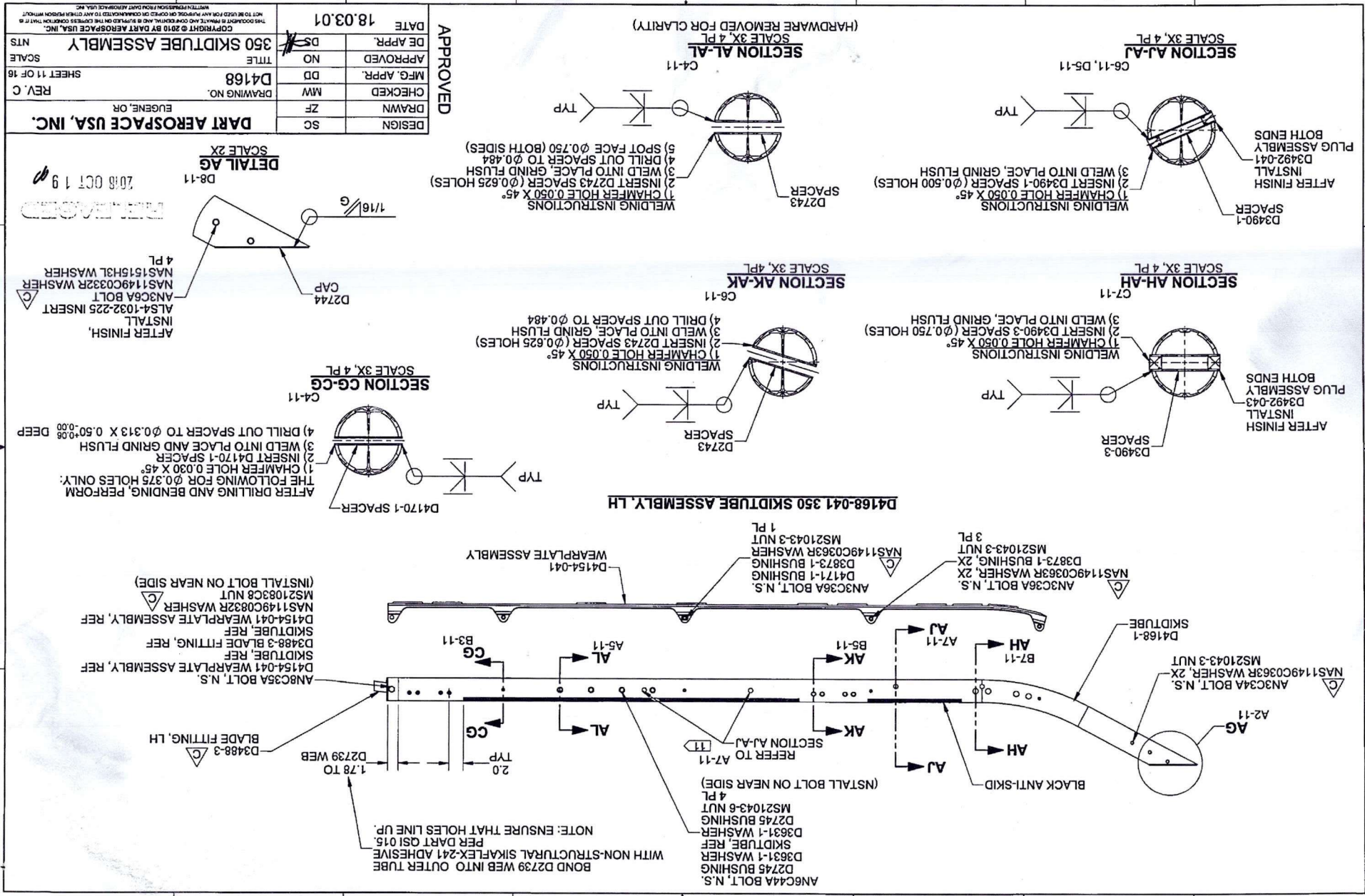
D4168-6 RH SKIDTUBE



MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)



2018 OCT 1 9 40
RECEIVED



DART AEROSPACE USA, INC.		DESIGN	SC
EUGENE, OR		DRAWN	ZF
REV. C		CHECKED	MW
D4168		MFG. APPR.	DD
SHEET 11 OF 16		APPROVED	NO
SCALE		DATE	18.03.01
350 SKIDTUBE ASSEMBLY		DE APPR.	DS

APPROVED

DATE 18.03.01

DE APPR. DS

APPROVED NO

MFG. APPR. DD

CHECKED MW

DRAWN ZF

DESIGN SC

DART AEROSPACE USA, INC.

EUGENE, OR

REV. C

SHEET 11 OF 16

SCALE

350 SKIDTUBE ASSEMBLY

NTS

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SECTION AG-AJ
SCALE 3X, 4 PL
C6-11, D5-11
AFTER FINISH
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDS
SPACER
D3490-1
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

SECTION AH-AH
SCALE 3X, 4 PL
C7-11
AFTER FINISH
INSTALL
D3492-043
PLUG ASSEMBLY
BOTH ENDS
SPACER
D3490-3
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-3 SPACER (Ø 0.750 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

SECTION AK-AK
SCALE 3X, 4 PL
C6-11
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø 0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø 0.484

SECTION CG-CG
SCALE 3X, 4 PL
C4-11
AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø 0.375 HOLES ONLY:
1) CHAMFER HOLE 0.030 X 45°
2) INSERT D4170-1 SPACER
3) WELD INTO PLACE AND GRIND FLUSH
4) DRILL OUT SPACER TO Ø 0.313 X 0.50 X 0.08 DEEP

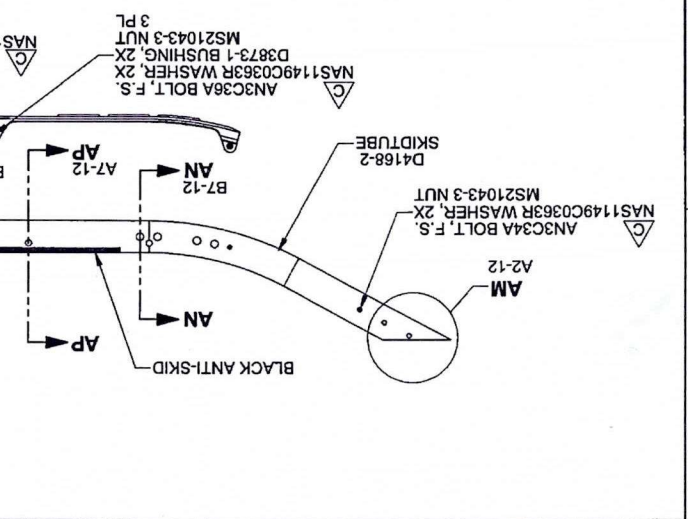
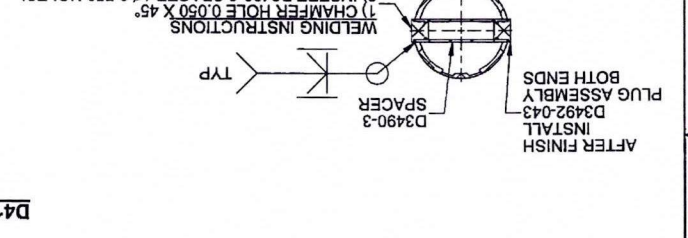
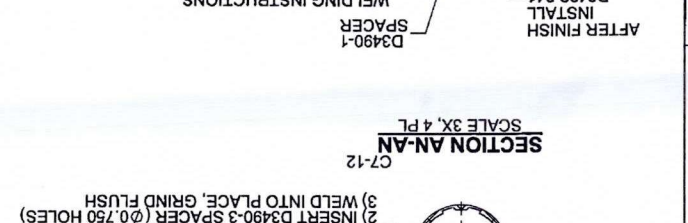
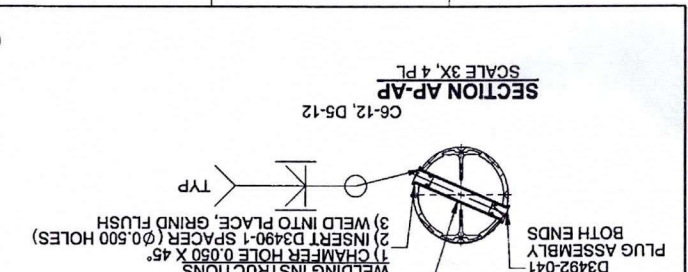
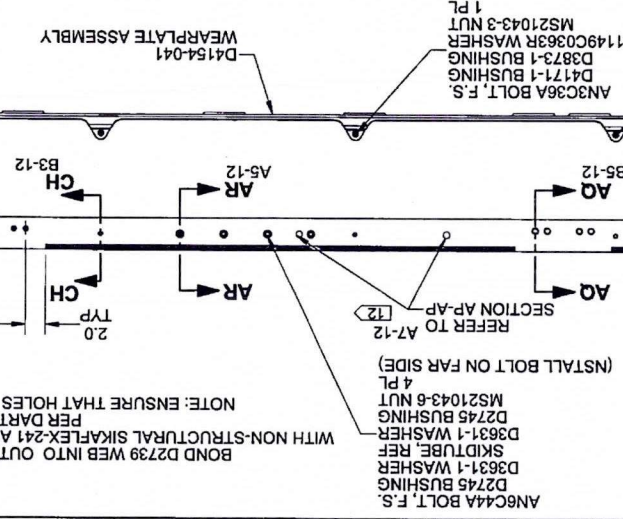
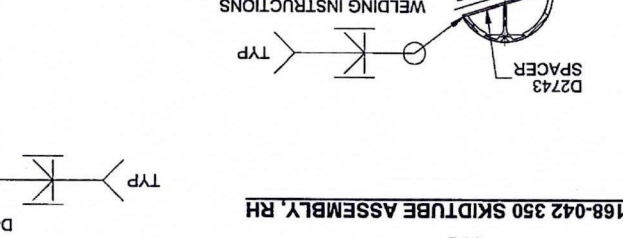
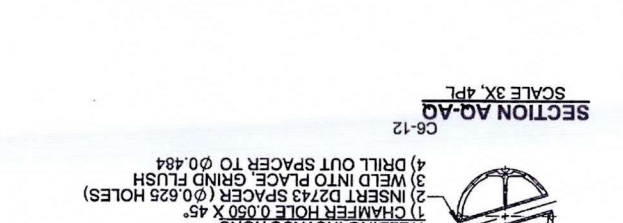
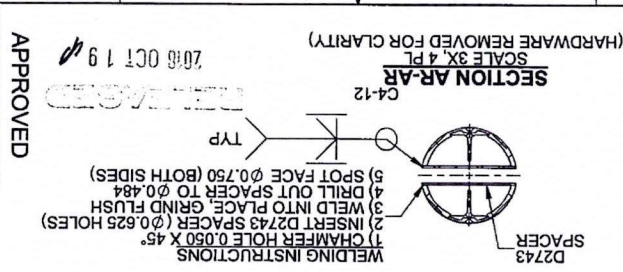
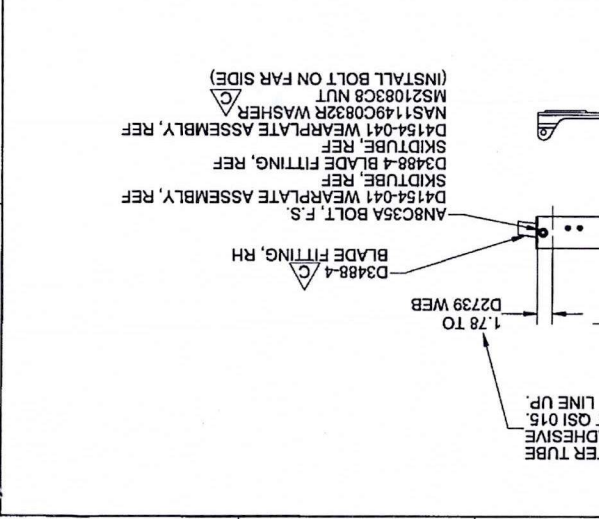
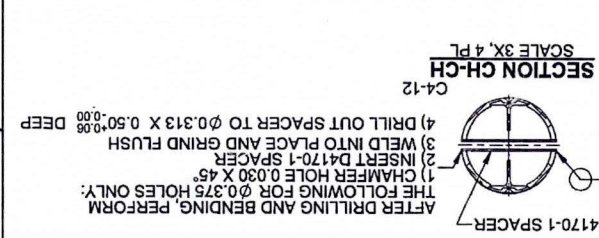
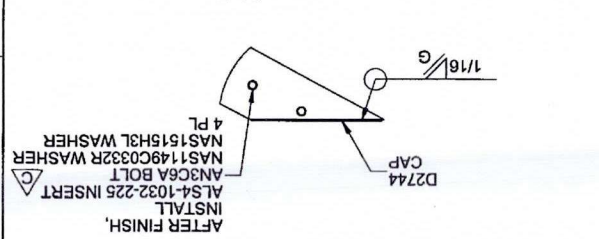
DETAIL AG
SCALE 2X
D8-11
1/16" G
C4P
D2744
AFTER FINISH, INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
NAS1149C0363R WASHER
NAS1515H3L WASHER
4 PL

D4168-041 350 SKIDTUBE ASSEMBLY, LH

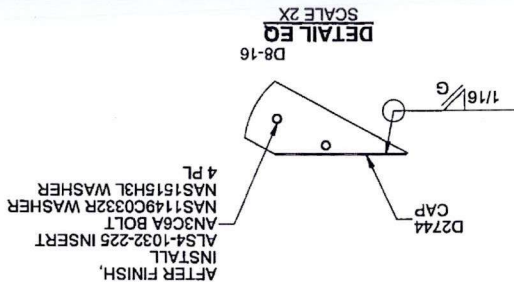
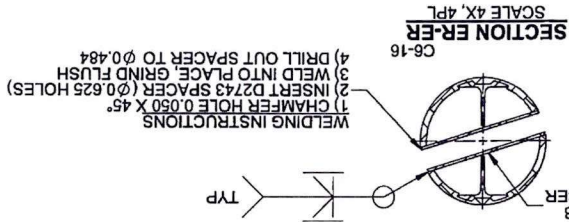
AG A2-11
AH A7-11
AJ A7-11
AK A7-11
AL A5-11
CG B3-11
D4168-1 SKIDTUBE
NAS1149C0363R WASHER, 2X
MS21043-3 NUT
AN3C36A BOLT, N.S.
D3873-1 BUSHING, 2X
MS21043-3 NUT
AN3C36A BOLT, N.S.
D3873-1 BUSHING
NAS1149C0363R WASHER
MS21043-3 NUT
AN3C36A BOLT, N.S.
D3873-1 BUSHING
WEARPLATE ASSEMBLY
D4154-041
BOND D2739 WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART OSI 015.
NOTE: ENSURE THAT HOLES LINE UP.
1.78 TO
D2739 WEB
D3488-3 BLADE FITTING, LH
AN3C36A BOLT, N.S.
D4154-041 WEARPLATE ASSEMBLY, REF
SKIDTUBE, REF
D3488-3 BLADE FITTING, REF
D4154-041 WEARPLATE ASSEMBLY, REF
SKIDTUBE, REF
MS21083C8 NUT
INSTALL BOLT ON NEAR SIDE)
D3488-3 BLADE FITTING, LH
2.0 TYP
1.78 TO
D2739 WEB
D3488-3 BLADE FITTING, LH
AN3C36A BOLT, N.S.
D4154-041 WEARPLATE ASSEMBLY, REF
SKIDTUBE, REF
D3488-3 BLADE FITTING, REF
D4154-041 WEARPLATE ASSEMBLY, REF
SKIDTUBE, REF
MS21083C8 NUT
INSTALL BOLT ON NEAR SIDE)

DESIGN	SC	DRAWN	ZF	CHECKED	MW	MFG. APPR.	DD	TITLE	D4168	DRAWING NO.	EUGENE, OR	REV. C	SHEET 12 OF 16	SCALE	NTS	DATE	18.03.01
DART AEROSPACE USA, INC.																	
350 SKIDTUBE ASSEMBLY																	
APPROVED																	
2018 OCT 19																	
18.03.01																	

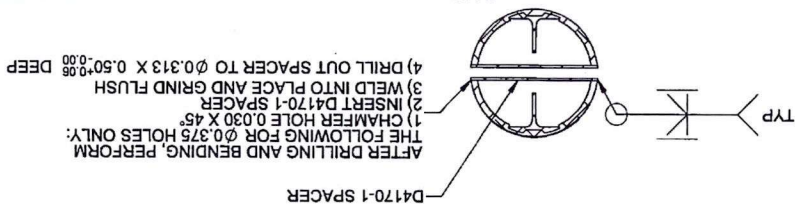
DETAIL AM
SCALE 2X
D8-12



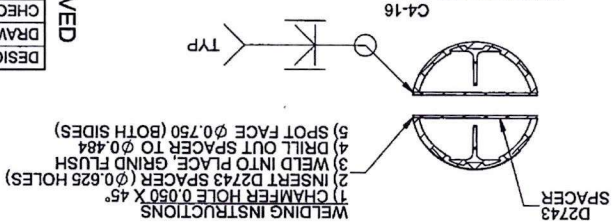
NOTE: ENSURE THAT HOLES LINE UP.
PER DART QSI 015.
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
BOND D2739 WEB INTO OUTER TUBE



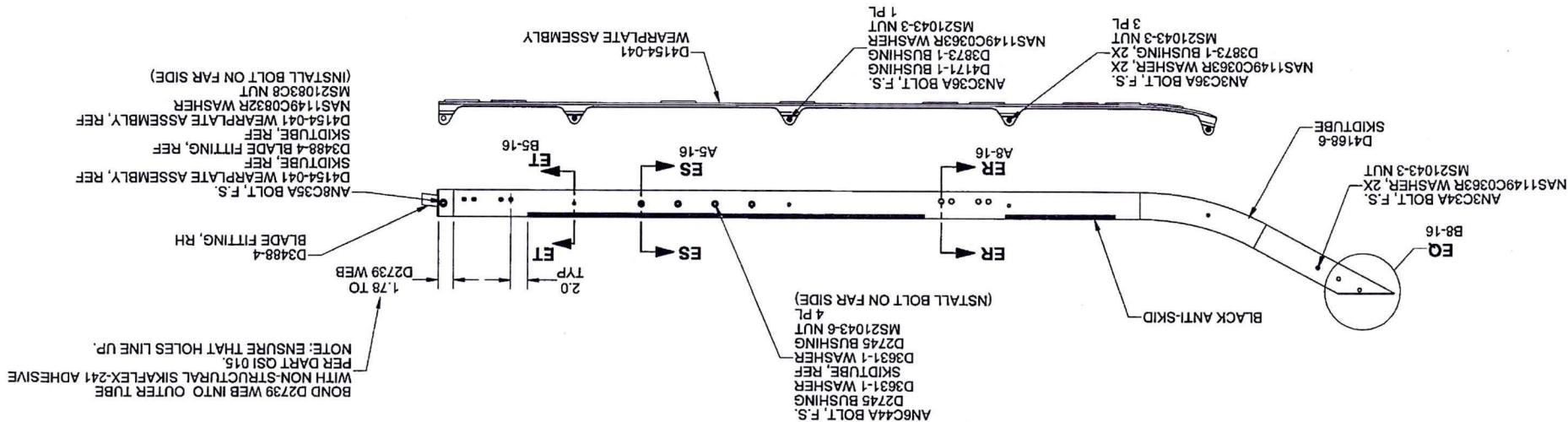
SECTION ET-ET
SCALE 4X, 4 PL
C4-16



SECTION ES-ES
SCALE 4X, 4 PL
(HARDWARE REMOVED FOR CLARITY)
C4-16



D4168-052 350 SKIDTUBE ASSEMBLY, RH



APPROVED

DESIGN	SC	DATE	18.03.01
DRAWN	ZF	DE APPR.	DS
CHECKED	MM	NO	NO
MFG. APPR.	DD	TITLE	350 SKIDTUBE ASSEMBLY
DRAWING NO.	D4168	SCALE	NTS
REV. C		SHEET 16 OF 16	

DART AEROSPACE USA, INC.

EUGENE, OR

2018 OCT 19

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Entered: _____ Date: _____

NCR No. _____

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Large Fab ☐ </td> <td style="width: 33%;"> Cross tube ☐ Small Fab ☐ Finishing ☐ </td> <td style="width: 33%;"> Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ </td> </tr> <tr> <td> Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐ </td> <td colspan="2"></td> </tr> </table>	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐						
Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐								

Date : _____	Sequence # : _____	QTY Affected : _____	Disposition
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Completed By	Lead hand / Supervisor	QC / QA Coordinator	
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY <table style="width: 100%;"> <tr> <td style="width: 33%;"> Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ </td> <td style="width: 33%;"> Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ </td> <td style="width: 33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ </td> </tr> <tr> <td> Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐ </td> <td colspan="2"></td> </tr> </table>	Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			Other/Details: _____ _____ _____
Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐						
Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐								

5177194

AEROSPACE

S177718



86-023

194169

o/Batch: S177118

C/K

10

: 21

Exp Date:
Instructions: FAA STC SR00646SE 18/10/17, TC STC SH99-7 Issue 2, EASA STI

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty	-015	-016	-017	-018	-023	-024	-047	Part Number	Description
		X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCROSSER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCROSSER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
						X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
							X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
								X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1		1							D4168-041	SKIDTUBE ASSEMBLY, LH
1			1						D4168-042	SKIDTUBE ASSEMBLY, RH
1				1					D4168-043	SKIDTUBE ASSEMBLY, LH
1					1				D4168-044	SKIDTUBE ASSEMBLY, RH
1						1			D4168-051	SKIDTUBE ASSEMBLY, LH
1							1		D4168-052	SKIDTUBE ASSEMBLY, RH
1									D4168-1	SKIDTUBE WELDMENT, LH
1			1						D4168-2	SKIDTUBE WELDMENT, RH
1									D4168-3	SKIDTUBE WELDMENT, LH
1				1					D4168-4	SKIDTUBE WELDMENT, RH
1					1				D4168-5	SKIDTUBE WELDMENT, LH
1							1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8	8	8	350A41-1027-20	SCREW
**3	8	8	8	8	8	8	8	8	23119AG120LE	WASHER
**4	8	8	8	8	8	8	8	8	22541N120	NUT
**5	1	1	1	1	1	1	1	1	AN8C35A	BOLT
**6A	1	1	1	1	1	1	1	1	NAS1149C0832R	WASHER
**7	1	1	1	1	1	1	1	1	MS21083C8	NUT
**8	1			1					D3488-3	BLADE FITTING, LH
**8			1						D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1	1	1	D2741	BLADE
10	2	2	2	2	2	2	2	2	AN8C21A	BOLT
11	2	2	2	2	2	2	2	2	NAS1149C0863J	WASHER
12	2	2	2	2	2	2	2	2	MS21083C8	NUT
**14	4	4	4	4	4	4	4	4	AN6C44A	BOLT
**15	8	8	8	8	8	8	8	8	D2745	BUSHING
**16	4	4	4	4	4	4	4	4	MS21043-6	NUT
**17	8	8	8	8	8	8	8	8	D3631-1	WASHER
**18	4	4	4	4	4	4	4	4	ALS4-1032-225	INSERT
**19	4	4	4	4	4	4	4	4	AN3C6A	BOLT
**20A	4	4	4	4	4	4	4	4	NAS1149C0332R	WASHER
**20B	4	4	4	4	4	4	4	4	NAS1515H3L	WASHER

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Date: 18.04.04

Item	Qty	-015	-016	-017	-018	-023	-024	-047	Part Number	Description
*30	8	8	8	8					D3492-041	PLUG ASSEMBLY
*31	8	8							D3492-043	PLUG ASSEMBLY
*32			8	8					D3492-045	PLUG ASSEMBLY
**43	2	2	2	2					D3493-1	WASHER
*90	1	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1		1	AN3C37A	BOLT ²
91C	1	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A				1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	7	8	D3873-1	BUSHING
94A				1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96								4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS
² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS
³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS
⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

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